

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-011064**Date Inspected:** 05-Jan-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Yu Qi Guo, Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** TOWER / OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Shrikant Utekar was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

HEAVY DOCK

This QA Inspector randomly observed the following work in progress.

WEST TOWER LIFT # 1

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 040736 performing Flux Cored Arc Welding process for weld WSD1-SA295B/E-08 located on PCMK the weld between P112 and P174 on skin D of West tower lift 1. ZPMC QC Mr. Yu Qi Guo monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-2333-TC-P4-F.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 202821 performing Flux Cored Arc Welding process for weld WSD1-SA295B/E-05 located on PCMK the weld between P112 and P176 on skin D of West tower lift 1. ZPMC QC Mr. Yu Qi Guo monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-2333-TC-P4-F.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 053486 performing Flux Cored Arc

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Welding process for weld WSD1-SA279-03 located on PCMK the weld between P189 and P169 on skin B of West tower lift 1. ZPMC QC Mr. Yu Qi Guo monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-2333-TC-P4-F.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 058792 performing Flux Cored Arc Welding process for weld WSD1-SA279-16 located on PCMK the weld between P587 and P169 on skin B of West tower lift 1. ZPMC QC Mr. Yu Qi Guo monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-2333-TC-P4-F.

TRIAL ASSEMBLY YARD

This QA Inspector randomly observed the following work in progress.

OBG SEGMENT 6 WEST

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 200676 performing Flux Cored Arc Welding process for weld SP413-001-030 located on PCMK side panel (counter weight side) stiffener to stiffener at the splice weld joint between OBG segment 6BW and 6CW. ZPMC QC Mr. Feng Ya Jun monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-B-U2-F.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 220066 performing Flux Cored Arc Welding process for weld OBW 6C-004 located on PCMK side panel (cross beam side) splice weld between OBG segment 6BW and 6CW. ZPMC QC Mr. Feng Ya Jun monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-T.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 053609 performing Flux Cored Arc Welding process for weld OBW 6C-005 located on PCMK side panel (cross beam side) splice weld between OBG segment 6BW and 6CW. ZPMC QC Mr. Feng Ya Jun monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-T.

OBG SEGMENT 6 EAST

This Quality Assurance (QA) Inspector observed ZPMC qualified welders 054467, 037743 performing Shielded Metal Arc Welding process for weld OBE6-002 located on PCMK deck panel splice weld between OBG segment 6AE and 6BE. ZPMC QC Mr. Zhang Xiao Ming monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-4G (4F) FCM- Repair-1.

Unless otherwise noted, all work observed on this dated appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, +(86) 1500 042 2372, who represents the Office of Structural Materials

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for your project.

Inspected By: Utekar,Shrikant

Quality Assurance Inspector

Reviewed By: Dawson,Paul

QA Reviewer